

Work Order ID 57425

April 6, 2010 4:00:03 PM



Page 1

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: BJDate: 10-4-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

SAN 10-04-09

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 111679

6- grind weld flush where indicated on dwg

2 Cpl 10-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

April 6, 2010 4:00:03 PM



Accept

**Setup Start**

Stop



Start Date: 06/04/2010 **Start Qty:** 2.00

**Cust Item ID:**

Required Date: 12/04/2010 **Req'd Qty:** 2.00.



Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



**Insp.
Stamp**

0.00



QC

Memo

0.00

Quality Control

② PD 10.02.13

0.00



OC

Memo

0.00

Quality Control

Solusi 13

$\frac{x2}{-042}$

0.00



Packaging

Memo

0.00

Packaging

Basophil cell

14 10/04/13 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 57425

April 6, 2010 4:00:03 PM



Page 3

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 06/04/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/04/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/14 *[Signature]*

BS 10-4-13

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

April 6, 2010 4:00:07 PM

Page 1

Work Order ID: 57425

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC


Start Date: 06/04/2010

Required Date: 12/04/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2327-3  Spacer Bushing		Manufactured	No			100	Each	31.0000	2.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

GPC 10-04-13

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

31

55917

11

57186

20

21

M304TS0.750W.065

Purchased

No

100

f

562.8397

3.7491



304 SQ Tube .75x.75x.065W



SAD

10-04-09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

562.8397

111148

58

113956

23.5

114137

481.3397

3.7491

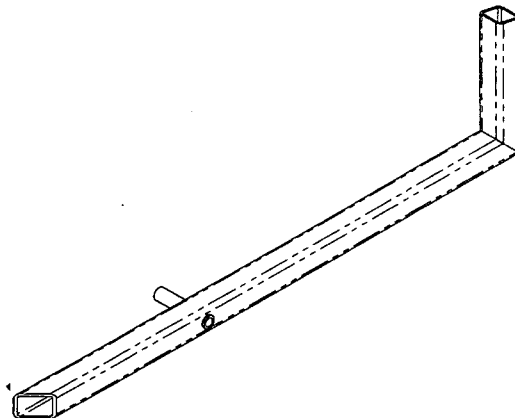
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

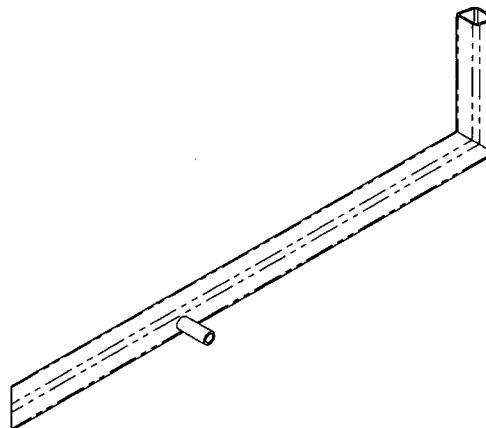
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NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.99 lbs EACH
 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
 RETURN TO
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 57425
BS10-4-04

RELEASED
BS10-4-04

A	NEW ISSUE	MB	08.09.24
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	<i>ASB</i>	DRAWING NO. D3836	REV. A
MFG. APPR.	<i>D</i>	SHEET 1 OF 3	
APPROVED	<i>lit</i>	TITLE	SCALE
DE APPR.	<i>#</i>	RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

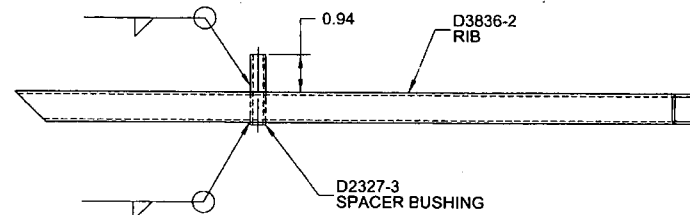
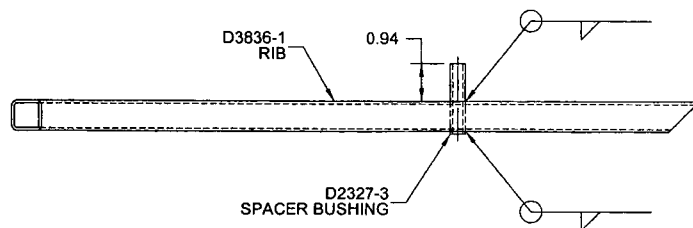
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

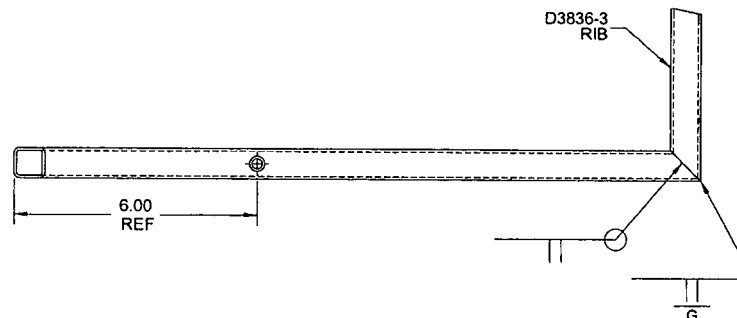
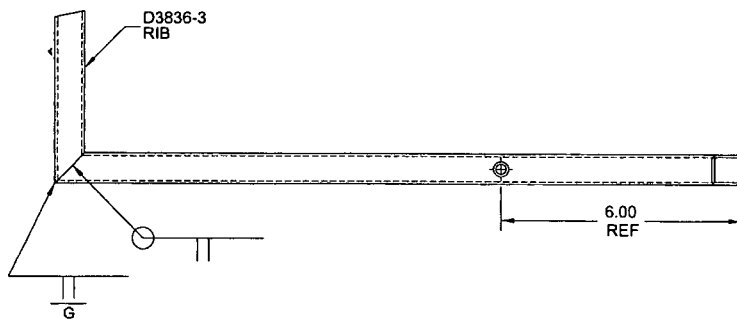
D

D



C

C



B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

W/O 57425

RELEASED
08/11/18

A

A

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3836
MFG. APPR.		REV. A
APPROVED		SHEET 2 OF 3
DE APPR.		TITLE RIB ASSY (BASKET LID)
DATE	08.09.24	SCALE NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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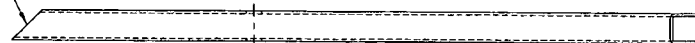
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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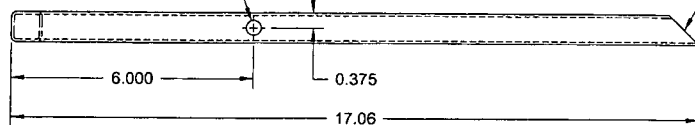
NOTE: Date & initial all entries

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CHAMFER

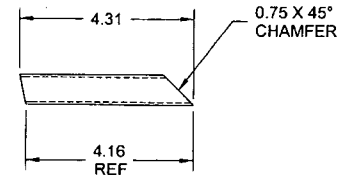


$\phi 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER

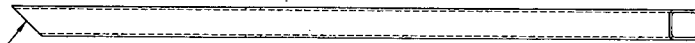


D3836-1 RIB



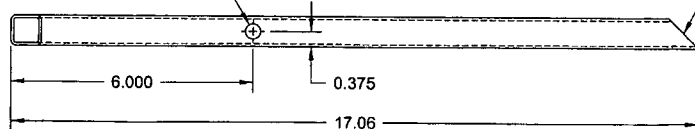
D3836-3 RIB

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CHAMFER

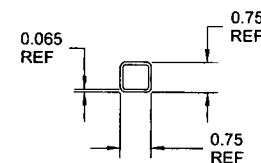


$\phi 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

w/0 57425

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
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